



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5957
Job Sheet 203130



Part No: D5957

Job Qty: 4 pcs

Part Name: Saddle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/11/19

Job Tracking No:

Due Date: 11/25/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:F ecn826 06.12.06 ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	4 pcs	11/25/19		0.00	0.00	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 19/11/19
							HAAS - 4		
100	HAAS 4 Axis - B4B	4 pcs	11/25/19		3.66	10.81	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		SBL 19/11/19
							HAAS - 4 - B4B		
110	QC 2	4 pcs	11/25/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



Container No: S231409



Part: D5957

Job No: 203130

Serial No/Batch: S231409

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/13/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

120 QC 8	4 pcs	11/25/19	0.00	0.00	QC 2 - 57	SBC 19/11/14 DAS 57 9-89
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
130 Handfinish - 1-1 Chemical- B4B	4 pcs	11/25/19	0.00	0.24	QC 8 - 8	DAS 52 17/11/15 J-89
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					Handfinish - 1 - 1 - B4B	BEB 19-11-18.
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 -	

				B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140	Powdercoat - 1 White GI(A)- B4B	4 pcs	11/25/19	0.00 0.19	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
150	QC 3	4 pcs	11/25/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
160	Packaging 3-1 - Stock - B4B	4 ✓ pcs	11/25/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B ✓
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B

Plex 11/11/19 9:19 AM Dart.lajeunesse.marie

					Packaging 3 - 12 - B4B						
					Packaging 3 - 13 - B4B						
					Packaging 3 - 14 - B4B						
					Packaging 3 - 15 - B4B						
					Packaging 3 - 16 - B4B						
					Packaging 3 - 17 - B4B						
					Packaging 3 - 18 - B4B						
					Packaging 3 - 19 - B4B						
					Packaging 3 - 20 - B4B						
					Packaging 3 - 21 - B4B						
					Packaging 3 - 22 - B4B						
					Packaging 3 - 23 - B4B						
					Packaging 3 - 24 - B4B						
					Packaging 3 - 25 - B4B						
					Packaging 3 - 26 - B4B						
					Packaging 3 - 27 - B4B						
					Packaging 3 - 28 - B4B						
					Packaging 3 - 29 - B4B						
					Packaging 3 - 30 - B4B						
					Packaging 3 - 31 - B4B						
					Packaging 3 - 32 - B4B						
					Packaging 3 - 33 - B4B						
					Packaging 3 - 34 - B4B						
					Packaging 3 - 35 - B4B						
					Packaging 3 - 36 - B4B						
					170 QC 21 - SA	4 pcs	11/25/19	0.00	0.00	QC 21 - SA - 21 ✓	ST399
										QC 21 - SA - 70	DAS
										QC 21 - SA - 53	21
					Part Op 100 - (HAAS CNC Vertical Machine), 1-Machine as per folio D5957,Ensure Batch Number is entered						NOV 28 2019
					Descriptions: 110 - Inspect on CMM as per folio CMMA016.						
					120 - (QC8- Inspect parts - second check)						
					130 - (Chemical Conversion Coat per QSI005 4.1)						
					140 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum), START TIME: _____						
					150 - (QC3- Inspect Part Finish)						
					160 - (Identify as per dwg & Stock Location: _____)						
					170 - (QC21- Final Inspection - Work Order Release)						

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	4 pcs (1 ea)	90-Machining - Issue SN	5228223x4
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6101-007	4	23	0
Part Specifications				
Specifications could not be found.				

Plex 11/11/19 9:19 AM Dart.lajeunesse.marie

203130

DART AEROSPACE LTD		Work Order: 200423
Description: Inner Aft Saddle		Part Number: D5957
Inspection Dwg: D5957	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.00	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.749	4.750	4.750	4.750		
G	0.315	0.322		0.315	0.315	0.315	0.315		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.052	3.052	3.052	3.052		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.315	0.315	0.315	0.315		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.500	0.501	0.502	0.502		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		7.994	7.996	7.996	7.998		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.308	0.313		0.312	0.312	0.312	0.312		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.498	0.496	0.498	0.498		
T	1.625	1.645		1.625	1.625	1.625	1.625		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V	0.023	0.043		0.033	0.033	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject								DAS	

Measured by: VHS / SBL 19/11/14	Audited by: 52
Date:	Date: 19/11/15

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.09.05	Dimension K revised	KJ/DD	
H	09.07.29	Dimension Q revised	KJ	

